

Date: Friday, 28/11/2008 3:05:22 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STEP LEG
<b>Job Number</b> : 43858C	
<b>Estimate Number</b> : 10382	
<b>P.O. Number</b> :	<b>Part Number</b> : D30655
<b>This Issue</b> : 28/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3065 REV. B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 28/11/2008 <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 42344C	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/12/2008 <b>Qty:</b> 100 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 28.12.01</u>	
<b>Comment</b> : Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM Est Rev:E Now manufactured with 6061-T6 06-05-25 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6S080	6061-T6 .080 Sheet
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**Comment:** Qty.: 1.1338 sf(s)/Unit Total : 113.3790 sf(s)  
 Material: 6061-T6 0.080" thick  
 (M6061T6S.080) Batch: 110254 B 8-12-29

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D  
 Dwg Rev: B  
 Prog Rev: B

B 8-12-29

2-Deburr if necessary B 8-12-29

(109)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

B 8-12-29

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

08.12.30

(108)

P70

counted

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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A4M 9-01-06

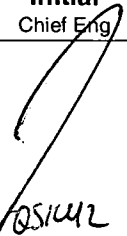
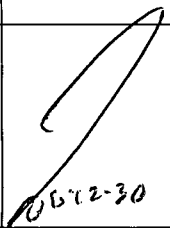
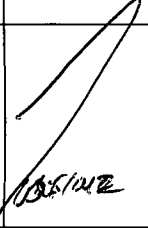
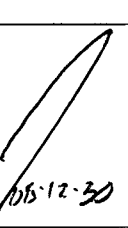
(108)

**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3065-5 PAR #: N/A Fault Category: Red / Med / Small NCR: Yes No DQA: A Date: 08/11/07  
D3065-041 - D350-571-311/321/213/214  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>43858C</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-12-30	2-0	2 parts scrap. Holes are out of alignment due to the material lifting. Shifting. 0.030". R.C. process.		Scrap 2 destroy Q1/2 No replace	B 8-12-30			

NOTE: Date & initial all entries

Date: Friday, 28/11/2008 3:05:22 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 43858C

Part Number: D30655

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

*09/01/07* (108)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *G-A*

*09/01/07* (108)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(108)

Comment: FINAL INSPECTION/W/O RELEASE

*09/01/07*

Job Completion



*u 09/01/07*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

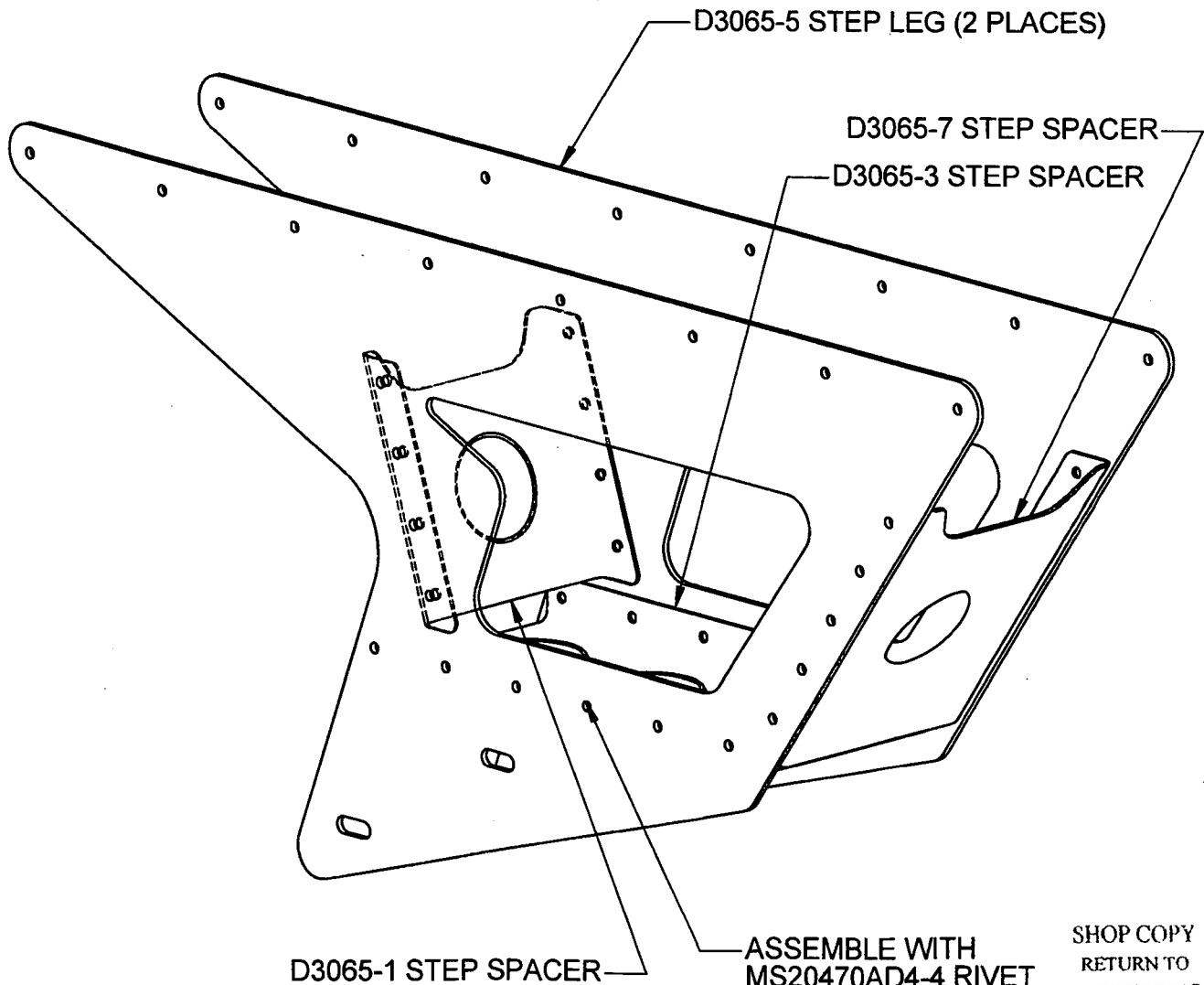


**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 1 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

**RELEASED**

*06.06.20* *[Signature]*



**D3065-041 STEP LEG ASSEMBLY**

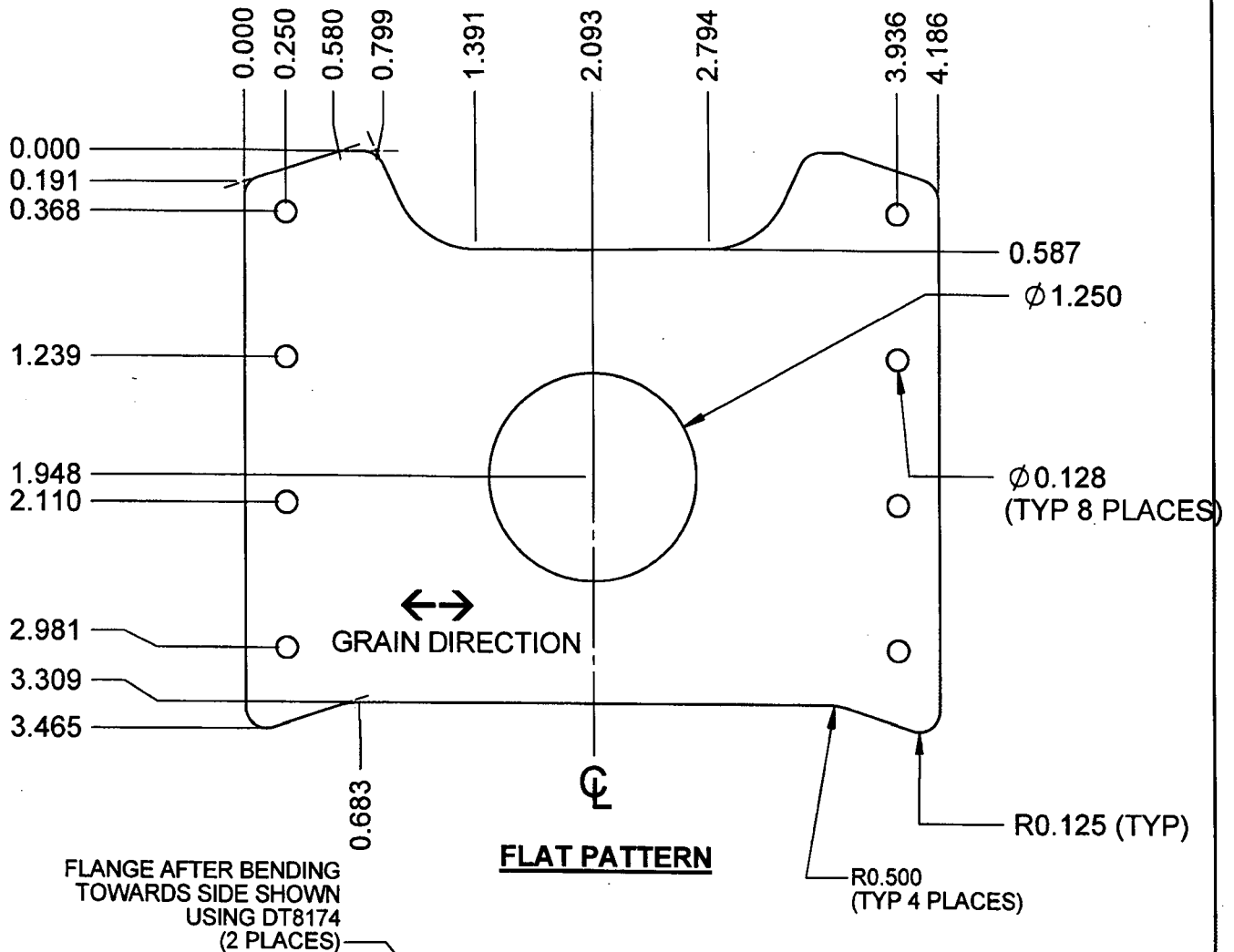
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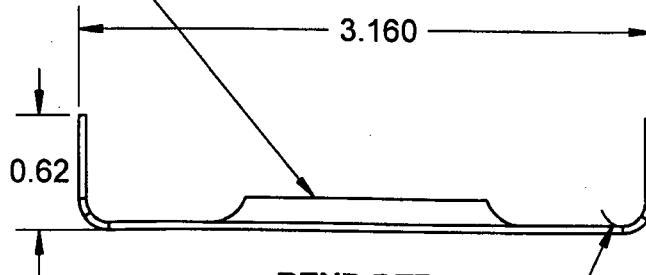


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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



RELEASED

*CP de-ro*



### D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S1040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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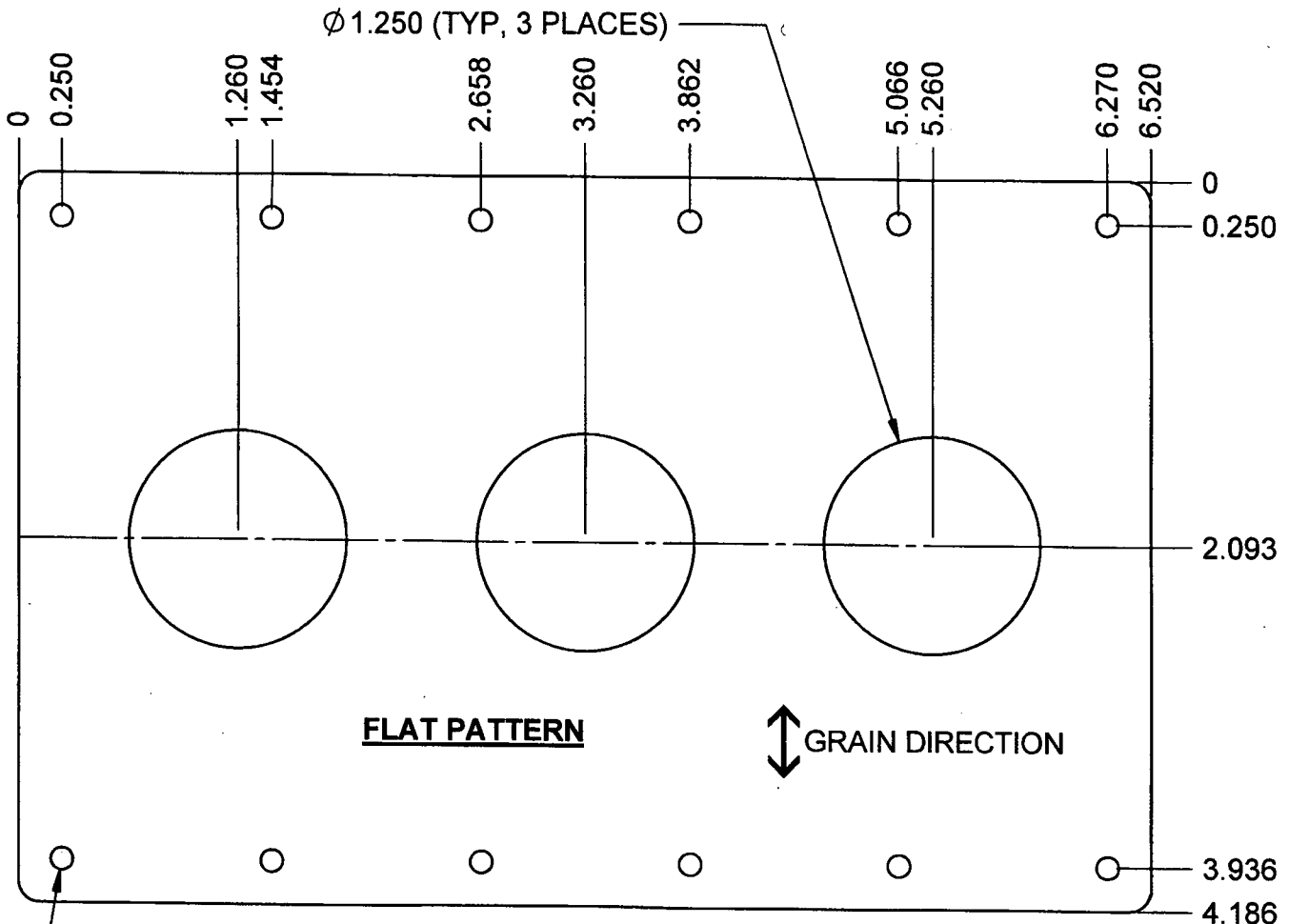
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DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>		SCALE 1:1

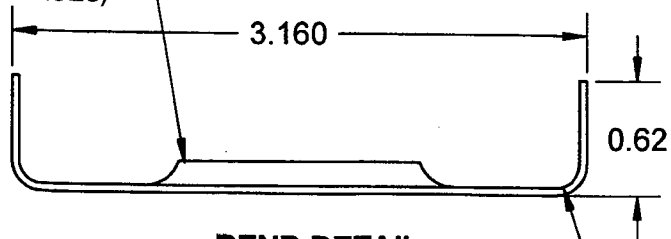


FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

**RELEASED**

*06 06 20* *[Signature]*



**BEND DETAIL**

**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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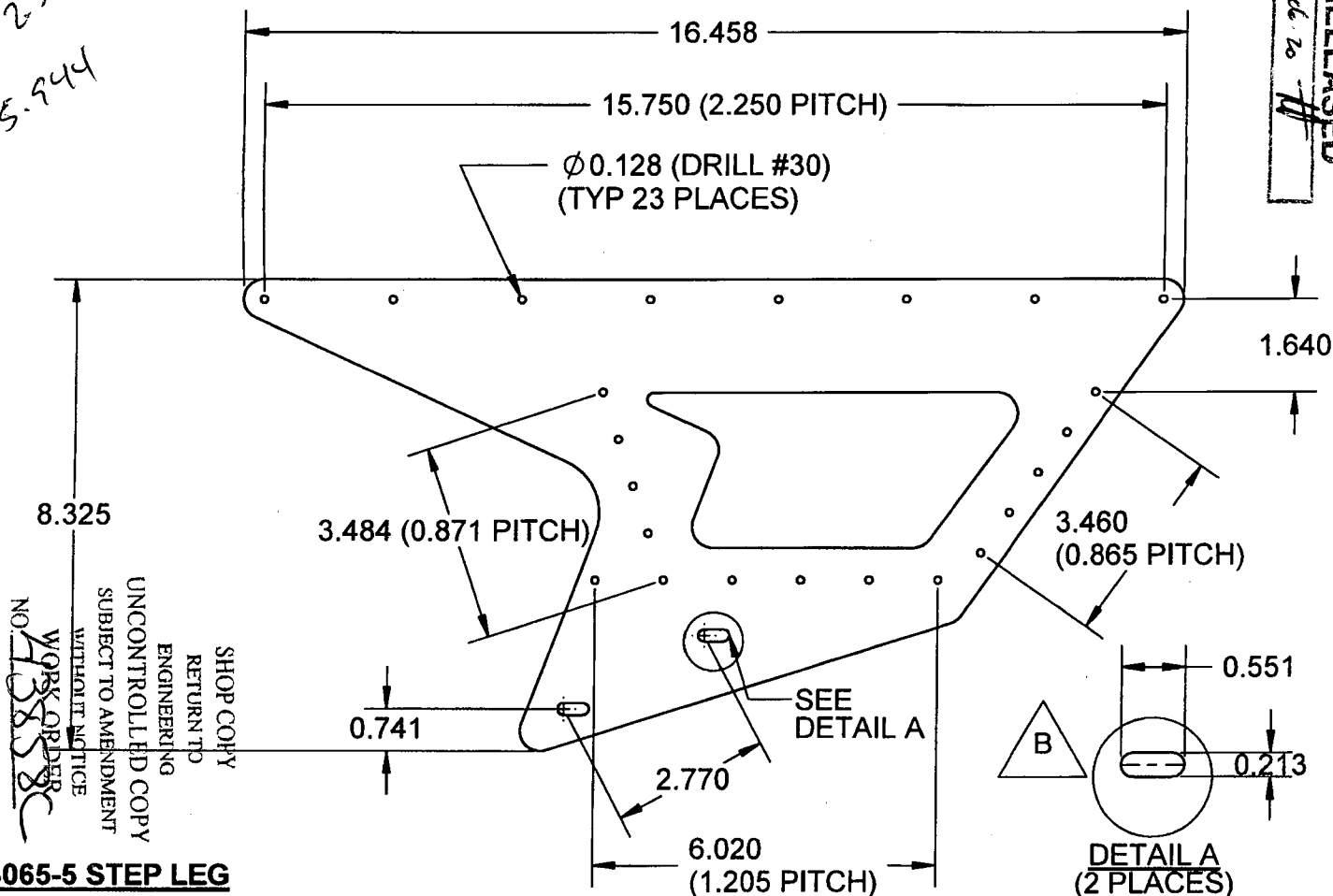


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C.P.	C.B.	DRAWING NO.	REV. B	
CHECKED 8/4	APPROVED 1/1	D3065	SHEET 4 OF 5	
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:3		

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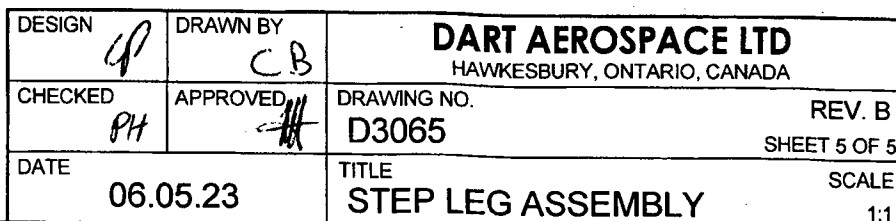
06.05.23

2381  
5.544**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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## FLAT PATTERN

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## WORK ORDER

NO. 738580

### D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC  
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
3) PART IS SYMMETRIC ABOUT CENTERLINE  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6) ALL DIMENSIONS ARE IN INCHES

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